

Date: Tuesday, 4/25/2006 7:35:05 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: LUG ASSEMBLY 206L/407 GHW LUG		
Job Number	: 26786			Part Number	: D2659	
Estimate Number	: 10318			Drawing Number	: D2659 REV A	
P.O. Number	: N/A			Project Number	: N/A	
This Issue	: 4/25/2006		S.O. No.	: N/A		
Prsht Rev.	: NC			Drawing Revision	: A	
First Issue	: N/A		Type	: PURCHASED PARTS		
Previous Run	: 21713			Material	: N/A	
Written By	: See Comment Below			Due Date	: 5/20/2006	
Checked & Approved By	: 06.04.25			Qty:	30	Um: Each
Comment	: Est: D 02.09.20 Re-format; Incorporated D2657; D2658 KJ/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	26786A	LUG	
		Comment: Sub-Component LUG	11/06/05/24 (30)
2.0	26786B	LUG BRACKET	
		Comment: Sub-Component LUG BRACKET	11/06/05/24 (30)
3.0	D2657	Lug	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)	
		Pick:	
	Qty Part# Description Batch	1 D2657 Lug	11/06/05/24 (30)
4.0	D2658	Lug Bracket	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 30.0000 Each(s)	
		Pick:	
	Qty Part# Description Batch	1 D2658 Lug Bracket	11/06/05/24 (30)
5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1	
		1-Weld as per Dwg D2659 using location Jig DT8484 M. F. 06.05.25	
		A/R Steel Rod 1118579	30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/06/07
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 4/25/2006 7:35:06 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG ASSEMBLY 206L/407 GHW LUG

Job Number: 26786

Part Number: D2659

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	QC5/9	WELD INSPECTION
Comment: WELD INSPECTION		11/06/05/25 (30)
7.0	POWDER COATING	POWDER COATING
Comment: POWDER COATING		
	Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	Am 06-05-31 (30)
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		11/06/05 30
9.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1		
Identify and Stock		
Location: 57141		Rugger (30)
10.0	DC	DOCUMENT CONTROL
Comment: DOCUMENT CONTROL		
Inspection Level 21		11/06/06 (30)

Job Completion



u 06-06-06

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

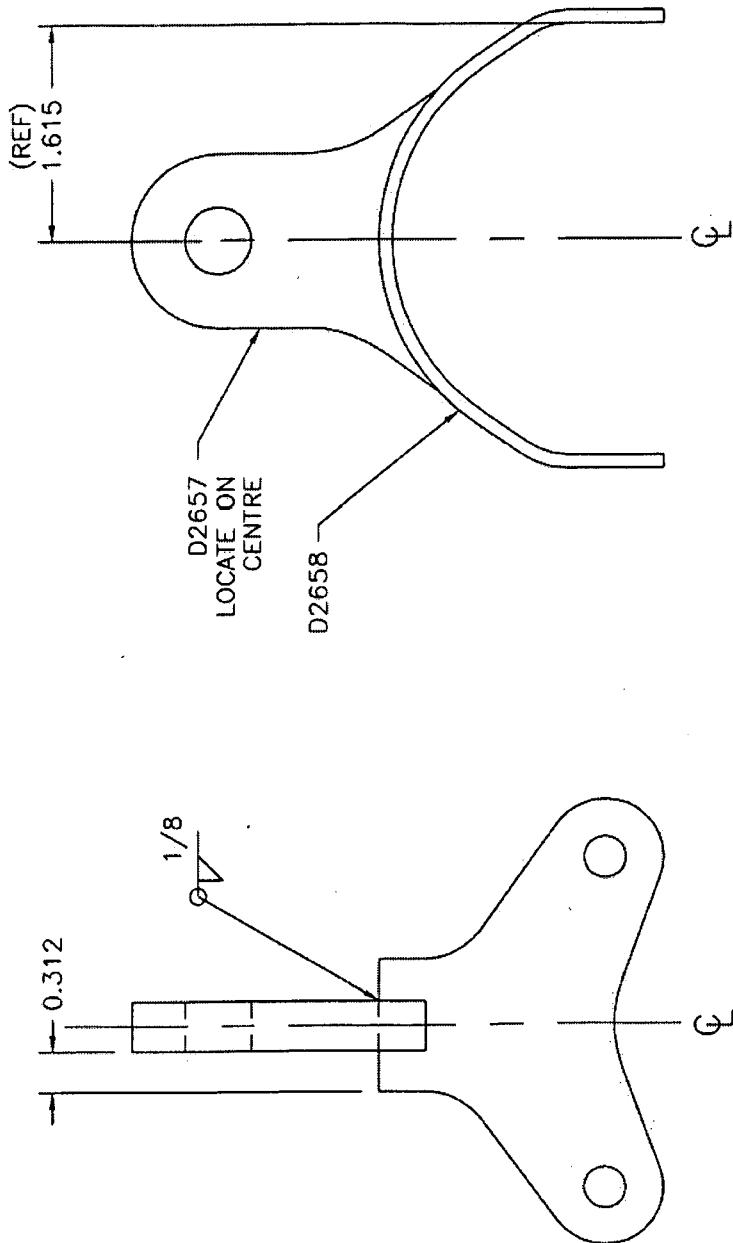
NOTE: Date & initial all entries

DART

DA COPY
D2659

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D2659	SHEET 1 OF 1
DATE		TITLE	SCALE
97.11.03		LUG ASSEMBLY	NTS
- A	97.11.03	NEW ISSUE	

RELEASED
97/11/06 DS



WELD PER DART QSI 004
FINISH: POWDER COAT PER DART QSI 005 4.4
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
PART IS SYMMETRIC ABOUT CENTRE-LINES (Q)

D2659 LUG ASSEMBLY

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26786